

Work Order ID 51624

August 27, 2009 8:27:35 AM

Page 1

Item ID: D3537-1 *GY*

Accept

Revision ID: C

Item Name: Wearpad

Setup Start

Stop

Start Date: 8/27/09 Start Qty: 100.00

Cust Item ID:

Required Date: 9/11/09 Req'd Qty: 100.00

Customer:

Reference:

Approvals:

Process Plan: *RL*

Date: *09-8-27*

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3537

Rev C

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3537 Dwg Rev: *C* Prog Rev: *C* 12-Deburr if necessary

1B 9-9-08

(105)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

1B 9-9-08

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

2) 8/27/09

counters (105) f

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 51624

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Page 2

Item ID: D3537-1

Accept



Setup Start



Revision ID: C

Stop



Item Name: Wearpad

Start Date: 8/27/09 Start Qty: 100.00



Cust Item ID:

Required Date: 9/11/09 Req'd Qty: 100.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00



NC BRAKE

Brake NC

Memo

0.00

Brake NC

1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326. 12-Identify as D3537-1

SB 09/6/20

105

140

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Qty Description Batch A/R 2059B Hardcoat
11-Weld as per Dwg D3537 using Jig DT 8210 12-Remove any weld that penetrated through Wearpad if necessary

M 109893 M 12807

SP 09.10.13

103K

150

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

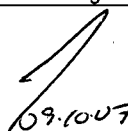
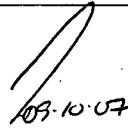
2) 809/10/14

QC10

103



4

(PB) ->

W/O: 51624		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
09-10-07	140	2 parts used for welding sample, to sample new type of Rch. Revise W/O quantity.				 09-10-07	 09-10-07	

Part No: D3537-1 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/16/07	# 140	Two parts scrapped due to testing a new welding Procedure R.C. Process		test failed Scrap and no Replan	 09-10-07 N/A			 09/16/07

NOTE: Date & initial all entries

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Item ID: D3537-1

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Revision ID: C

Item Name: Wearpad

Start Date: 8/27/09

Start Qty: 100.00

Required Date: 9/11/09

Req'd Qty: 100.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

170

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Powdercoat

Memo

0.00

Powder Coating

START TIME:

8:30am

FINISH TIME:

OVEN TEMPERATURE:

320°F

180

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 51624

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Item ID: D3537-1

Accept



Setup Start



Revision ID: C

Stop



Item Name: Wearpad

Start Date: 8/27/09 Start Qty: 100.00



Cust Item ID:

Required Date: 9/11/09 Req'd Qty: 100.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Identify as per dwg & Stock Location: FP-17

0.00

del 09/10/15

(X102) 0



Packaging

Memo

0.00

Packaging

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/15 AD
MF 09-10-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 51624

Parent Item: D3537-1RevC

Parent Item Name: Wearpad

Comments:

Start Date: 8/27/09

Required Date: 9/11/09

Start Qty: 100.00

Required Qty: 100.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	150.0498	11.1579	11.7157		



304/316 Sheet .063



13-9-08

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

150.0497737

106860

16.018

111924

33.0549737

112290

100.9768

112567

112567

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

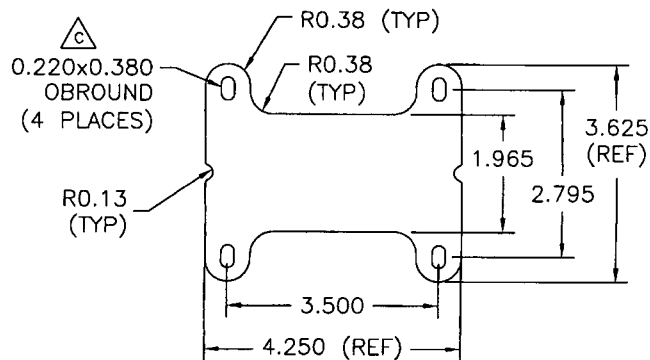
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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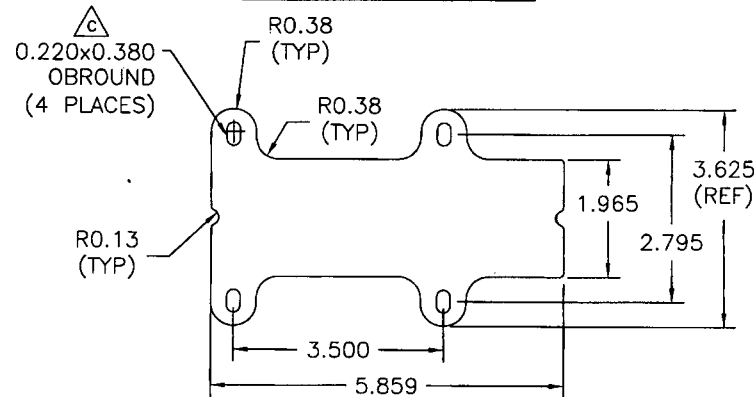
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO. 51624

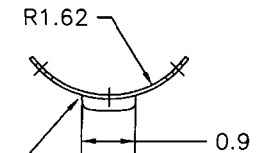
D3537-1F FLAT PATTERN



D3537-3F FLAT PATTERN

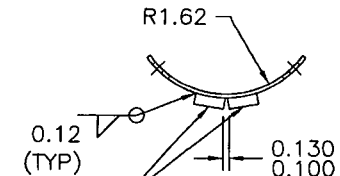


SECTION A-A



APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

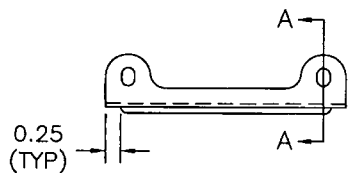
SECTION B-B



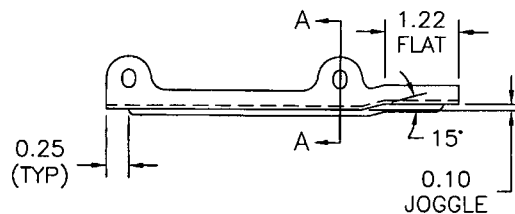
D2941-300
REMOVE POWDER
COAT FROM THESE
SURFACES

RELEASED
07.05.08 AM
per ECU
962

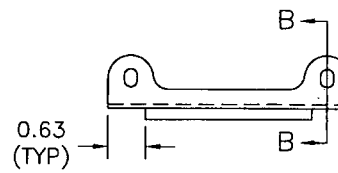
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



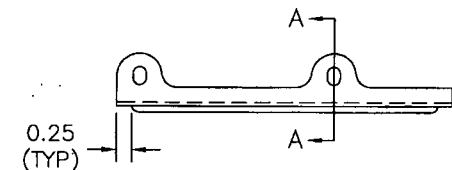
D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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DART AEROSPACE USA, INC.

C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	CB	DRAWN BY PH
CHECKED	#	APPROVED #
DATE	07.04.13	TITLE WEARPAD
DRAWING NO.	D3537	REV. C
DART AEROSPACE USA, INC.	PORT HADLOCK, MA	SHEET 1 OF 1
		SCALE 1:2